

Work Order ID -56061

February 9, 2010 1:26:04 PM



Page 1

Item ID: D3443-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Weldment Assembly

Start Date: 2/09/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: PD Date: 10-2-09 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3443	Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3443

PL 10-6-29 (XS)

Buff = 7m-h 10/07/05 (SX)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(S) PD 10.07.01

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sw 67/06

(XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56061

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

M 114841

0.00

Powder Coating

1-Mask holes as per dwg D3443

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:10/400°
12:40

5 BL 10-7-12

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-7-12 SD (50)

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

EP 10/67/28 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56061

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Item ID: D3443-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Weldment Assembly

Start Date: 2/09/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

S 10/07/28



QC

Memo

0.00

15

Quality Control

170

Identify as per dwg & Stock Location: 198A

0.00



Packaging

Memo

0.00

10/07/28 (5)

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/07/29

Quality Control

W 1007.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 9, 2010 1:26:10 PM

Page 1

Work Order ID: 56061

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly



Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Date: 2/09/10

Required Date: 2/15/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3443-1		Manufactured	No			100	Each	5.0000	4.0000			
												
Lug												

EL 10-6-29

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

46143

1

Main Warehouse

WA

4

53698

4

D3443-5

Manufactured No



Tubing

D3453-1

Manufactured No



Clevis

B 58562 x 5
B 56594 x 4 58563 x 1

100 Each 0.0000 4.0000



EL 10-6-29

100 Each 14.0000 4.0000



EL 10-6-29

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

10

53732

10

Main Warehouse

st92

4

52986

4

B 58564 x 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

February 9, 2010 1:26:11 PM

Work Order ID: 56061

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Date: 2/09/10

Required Date: 2/15/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3965-4 Manufactured No



Bearing, Spherical

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

53680

100

8

8

Each

31.0000

8.0000



BS6384 107-125
B60479 SB 10/07/27

D3966-4-750



Pin, Dowel

Manufactured No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

53631

31

31

58711 x10

EL 10-6-29

February 9, 2010 1:26:11 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

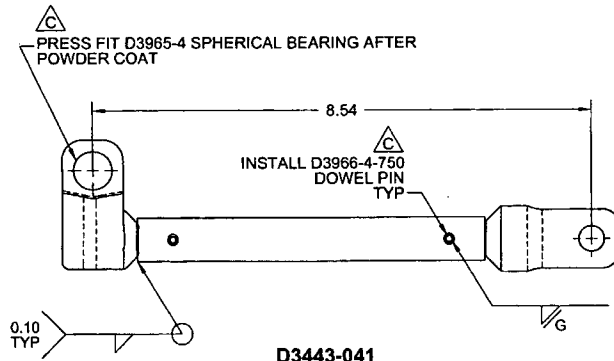
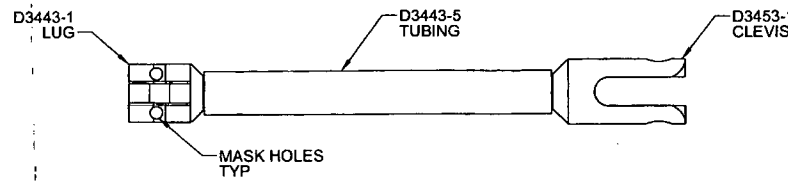
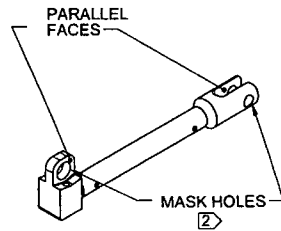
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56061

10-2-09

RELEASED
09/08/25 MP

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.561 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAINAUR PIN (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR PIN (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & 0.0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3443** REV. C
SHEET 1 OF 4
TITLE **STRUT WELDMENT ASSEMBLY** NTS
SCALE

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8 7 6 5 4 3 2 1

8

7

6

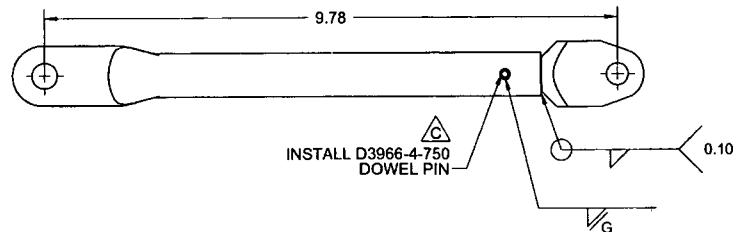
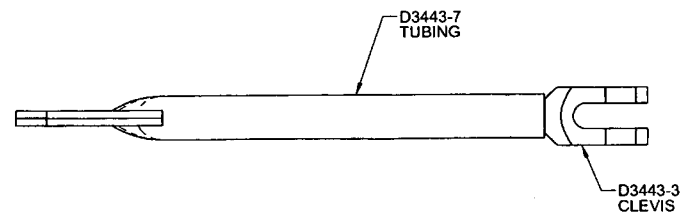
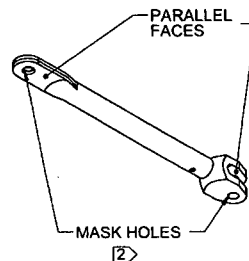
5

4

3

2

1

**D3443-043****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN

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 09/06/25/14

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6

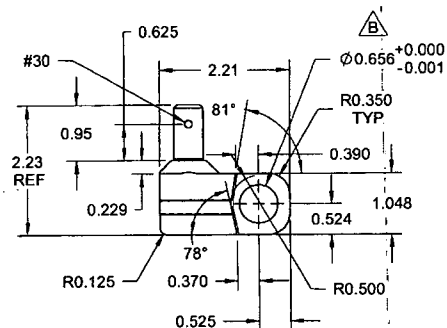
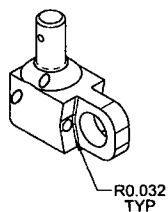
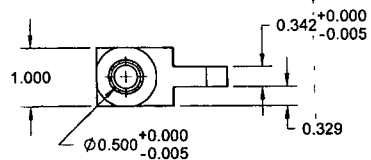
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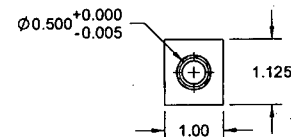
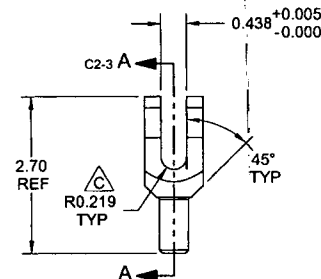
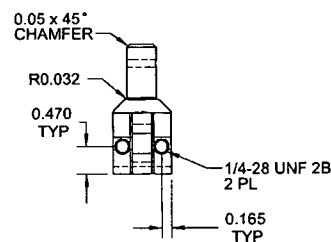
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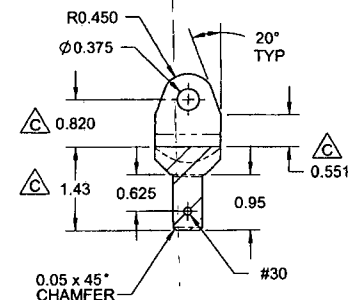
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D3443-1 LUG



D3443-3 CLEVIS



SECTION A-A C4-3



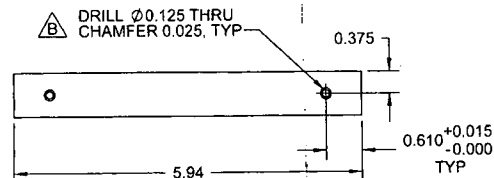
NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

RELEASED
01/28/25/14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO. D3443	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 4
APPROVED		STRUT WELDMENT ASSEMBLY NTS	SCALE
DE APPR.			
DATE	09.06.25		

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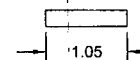
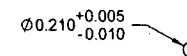
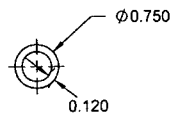


D3443-5 TUBING



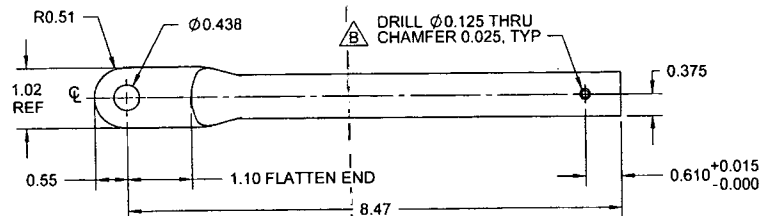
D3443-7 TUBING

- D3443-5/-7 NOTES:**
 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: D3443-5 = 0.41 lbs
 D3443-7 = 0.62 lbs



D3443-9 PIN

- D3443-9 NOTES:**
 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: N/A



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 01/08/25 MD

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 4 OF 4
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